



HEAT-FLEX® 750

Revised: 08/23 Issue 2

PRODUCT DESCRIPTION

Heat-Flex® 750 is a high solids micaceous iron oxide filled alkylated amide epoxy providing both corrosion resistance and high temperature resistance. The micaceous iron oxide provides higher temperature resistance, improved anticorrosion performance, film reinforcement, tolerance to over film thickness, and lower moisture permeation.

INTENDED USES

- External protection for process pipes, valves and vessels operating continuously between the temperatures of -196°C and 204°C.
- Suitable for use on both carbon and stainless steel in insulated, uninsulated and cryogenic environments

PRODUCT DATA

Finish: Flat

Colours: Grey and Dark Grey

Volume Solids: 78% ± 3%, mixed (ASTM-D2697-91)

VOC (EPA Method 24), mixed: <250 g/L; 2.1 lb/gal

Mix Ratio: 4:1 by volume

Typical Thickness:

Recommended Spreading Rate Per Coat

	Min	Max
Wet µm (mils)	125 (5)	256 (10.2)
Dry µm (mils)	100 (4)	200 (8)
~Coverage m ² /L	3.9	7.8
Theoretical coverage (m ² /L) at 25µm (1 mil) DFT	30.7	

NOTE: Brush or roll application may require multiple coats to achieve max film thickness and uniformity of appearance.

Shelf Life: 12 months, unopened. Store indoors at 5°C to 38°C.

Flash Point: Part A: 41°C
Part B: 43°C

Reducer/Clean Up: M.E.K. or similar

Weight: 2.08 Kg/L ± 0.25, mixed

Average Drying Times:

	15°C	23°C	35°C
Touch:	1¼ hrs	45 mins	30 mins
Handle:	10 hrs	6 hrs	3 hrs
Recoat:	Min:	6 hrs	4 hrs
	Max:	7 days	7 days

Pot Life:

	15°C	23°C	35°C
	2½ hrs	1½ hrs	1 hr

Pot life is dependent upon temperature and mass.

Sweat-in-time: none required

If max recoat time is exceeded, abrade surface before recoating.
Drying time is temperature, humidity, and film thickness dependent.

SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to coating application, surfaces should be assessed and treated in accordance with ISO 8504:2000. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Min recommended surface preparation:

Iron & Steel: Abrasive blast clean to Sa2½ (ISO 8501-1:2007), SSPC-SP6/NACE 3, 50 - 75µm (2 - 3 mil) profile.

For weld areas and small touch up repairs, power tool cleaning to SSPC-SP11 is suitable. Optimal performance will be achieved with a minimum surface profile of 2 mils (50 microns).

Stainless Steel: Abrasive blast clean SSPC-SP16 with non-metallic abrasive, 25µm (1 mil) profile.



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APPLICATION

Airless Spray

Pressure: 151 bar (2200 psi) min
Tip: 0.38 - 0.48 mm (0.015" - 0.019")

Conventional Spray

Atomization Pressure: 3.4 bar (50 psi)
Fluid Pressure: 0.3 bar (5 psi)
Reduction: As needed up to 10% M.E.K. by volume

Brush*

Brush: Natural Bristle
Reduction: As needed up to 10% M.E.K. by volume

Roller*

Cover: 3/8" woven with solvent resistant core
Reduction: As needed up to 10% M.E.K. by volume to aid flow and leveling

*Application of more than one coat may be necessary to give equivalent dry film thickness to a single spray applied coat.

If specific application equipment is not listed above, equivalent equipment may be substituted.

RECOMMENDED SYSTEMS

Steel or Stainless Steel:

1 x Heat-Flex® 750 @ 125 - 200µm (5 - 8 mils) DFT
1 x Heat-Flex® 750 @ 125 - 200µm (5 - 8 mils) DFT

APPLICATION CONDITIONS

Temperature

Air & Material: 10°C min, 49°C max
Surface: 10°C min, 100°C max. At least 2.8°C above dew point
Relative humidity: 90% max

APPROVALS

- Tested in accordance with ISO 19277 Houston pipe test CUI 3
- ISO 12944 C5H R1
- ISO 12944 CX

APPLICATION CONDITIONS

Do not tint.

Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.

Do not mix previously catalyzed material with new.

If an aesthetic finish is required for ambient temperatures up to 120°C, then Heat-Flex® 750 is compatible with a wide range of Sherwin-Williams polyurethane, polysiloxane and NCO free finishes. At temperatures above 120°C, please consult with your Sherwin-Williams Representative.

WARRANTY

Any person or company using the product without first making further enquiries as to the suitability of the product for the intended purpose does so at their own risk, and Sherwin-Williams can accept no liability for the performance of the product, or for any loss or damage arising out of such use.

The information detailed in this datasheet is liable to modification from time to time in the light of experience and normal product development, and before using, customers are advised to check with Sherwin-Williams, quoting the reference number, to ensure that they possess the latest issue.

DISCLAIMER

The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin-Williams representative to obtain the most recent Product Data Information and Application Bulletin.

HEALTH AND SAFETY

Consult Safety Datasheet for information on safe storage and handling of this product.

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